

Non Eurocopter

Work Order ID 60767

Thursday, July 22, 2010 10:53:04 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 7/22/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *PP*

Date: *10-7-21* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001 002

8/4/04 1.7

PP 10-7-21

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

PP 10.08.04 4

PP

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *m112860*
m114242

3-Grind End Plate flush

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 10.09.04

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.08.04

x4

RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H 10.08.04

4

P

W/O:		WORK ORDER CHANGES					
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[illegible]

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Accept

[illegible]

Setup Start

Stop

11/11/2010

Cust Item ID:[illegible]

Customer:

Reference:

Run Start

Stop

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod ☒ *m112860*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

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Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							PD 10.08.09
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							Subtotal
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							10 08 10 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	M115291								
	Powdercoat	0.00							

Powder Coating

Memo

START TIME: 3:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 4:00pm

230	Wing Walk as per dwg QSI005 4.4 Batch 115028	0.00							
-----	--	------	--	--	--	--	--	--	--

HandFinish

Hand Finishing

Memo

240	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

QC

Quality Control

Memo

Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>72</u>								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Required Date: 7/29/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/18

MF

10-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, July 22, 2010 10:53:09 AM

Required Qty: 4.00

59972

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, July 22, 2010 10:53:09 AM

Work Order ID: 60767

Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/22/2010



Required Date: 7/29/2010

Start Qty: 4.00



Required Qty: 4.00

D3065-041	Manufactured	No	180	Each	34.0000	1	4
							<u>10.08.04</u>
Step Leg Assembly Hi							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	34	
58536	4	
<u>59678</u>	30	

D3066-1	Manufactured	No	180	Each	143.0000	2	8
							<u>10.08.04</u>
Spacer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	143	
58540	77	
<u>60194</u>	66	

D3067-1	Manufactured	No	180	Each	21.0000	1	4
							<u>10.08.04</u>
End Plate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA <u>860141</u>	21	
59596	21	

D3219-1	Manufactured	No	180	Each	73.0000	2	8
							<u>10.08.04</u>
Plate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	73	
<u>59597</u>	73	

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Work Order ID: 60767

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W4

Purchased

No

180

Each

627.0000

16

64



Rivets



10.08.05

Location

Loc Qty

Loc Code

ST321

627

113368

62

114181

11

114718

2

114935

552

Purchased

No

250

Each

157.0000

2

104

AN3-35A

Bolt



10/8/11/84

Location

Loc Qty

Loc Code

ST353

157

115016

57

115108

100

Purchased

No

250

Each

1,082.000

8

32

AN4-13A

Bolt



10/8/17/84

Location

Loc Qty

Loc Code

ST357

582

114941

82

115108

500

ST358

500

115159

500

32

Thursday, July 22, 2010 10:53:09 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

AN5-36A Purchased No 250 Each 203.0000 2
Bolt

Location

Loc Qty

Loc Code

ST341

203

114292

5

114941

198

AN960JD10 NAS1149D0363J Purchased No 250 Each 0.0000 4
Washer

AN960JD416 NAS1149D0463J Purchased No 250 Each 0.0000 16
Washer

AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000 4
Washer

D2230-3 Manufactured No 250 Each 35.0000 4
Lug

Location

Loc Qty

Loc Code

ST476

35

55452

2

59115

1

59418

32

8
10/8/17 SP

8

16
M115107 10/8/17 SP

64
M115000 10/8/17 SP

16
M114742 10/8/17 SP

16
60191 10/8/17 SP (42)

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Page 4

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Page 5

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Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

D2618

Manufactured No

250

Each

105.0000

2

8



Bushing



10/8/17 SD

Location

Loc Qty

Loc Code

ST019

103

59425

3

60193

100

ST020

2

56892

1

57829

1

D2856-400

Manufactured No

250

f

362.2188

0.6

2.4



Abraison Strip



10/8/17 SD

Location

Loc Qty

Loc Code

ST403

362.2188421

56626

146.218842

59920

216

D3235-1

Manufactured No

250

Each

43.0000

2

8



Mounting Lug



10/8/16 SD

Location

Loc Qty

Loc Code

ST471

43

59125

43

D3278-041

Manufactured No

250

Each

70.0000

1

4



Support Assembly



10/8/16 SD

Location

Loc Qty

Loc Code

ST471

70

59633

30

60201

40

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Page 5

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Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

250

Each

2,606.000

2

8

Nut

Location

Loc Qty

Loc Code

ST300

2606

114523

130

114718

476

114784

2000

MS21042L4

Purchased

No

250

Each

3,911.000

8

32

Nut

Location

Loc Qty

Loc Code

ST300

3911

113422

68

114523

28

114718

23

114784

1792

115108

2000

MS21042L5

Purchased

No

250

Each

821.0000

2

18

Nut

Location

Loc Qty

Loc Code

ST139

321

114813

321

ST300

500

115156

500

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DART

DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	* REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07 06 04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005.4.3
BLACK ANTI-SKID PAINT PER DART QSI 005.4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *46767*

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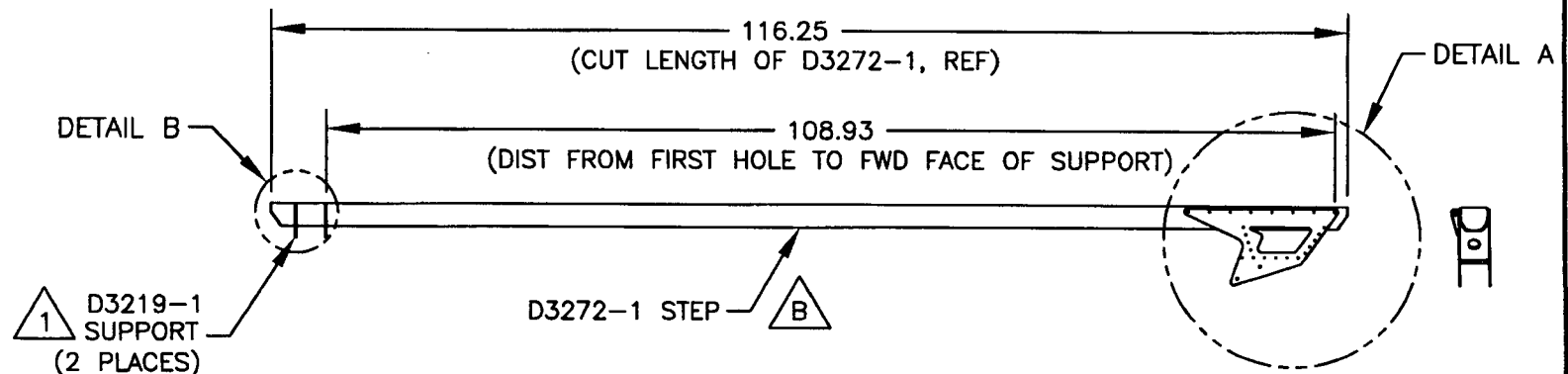
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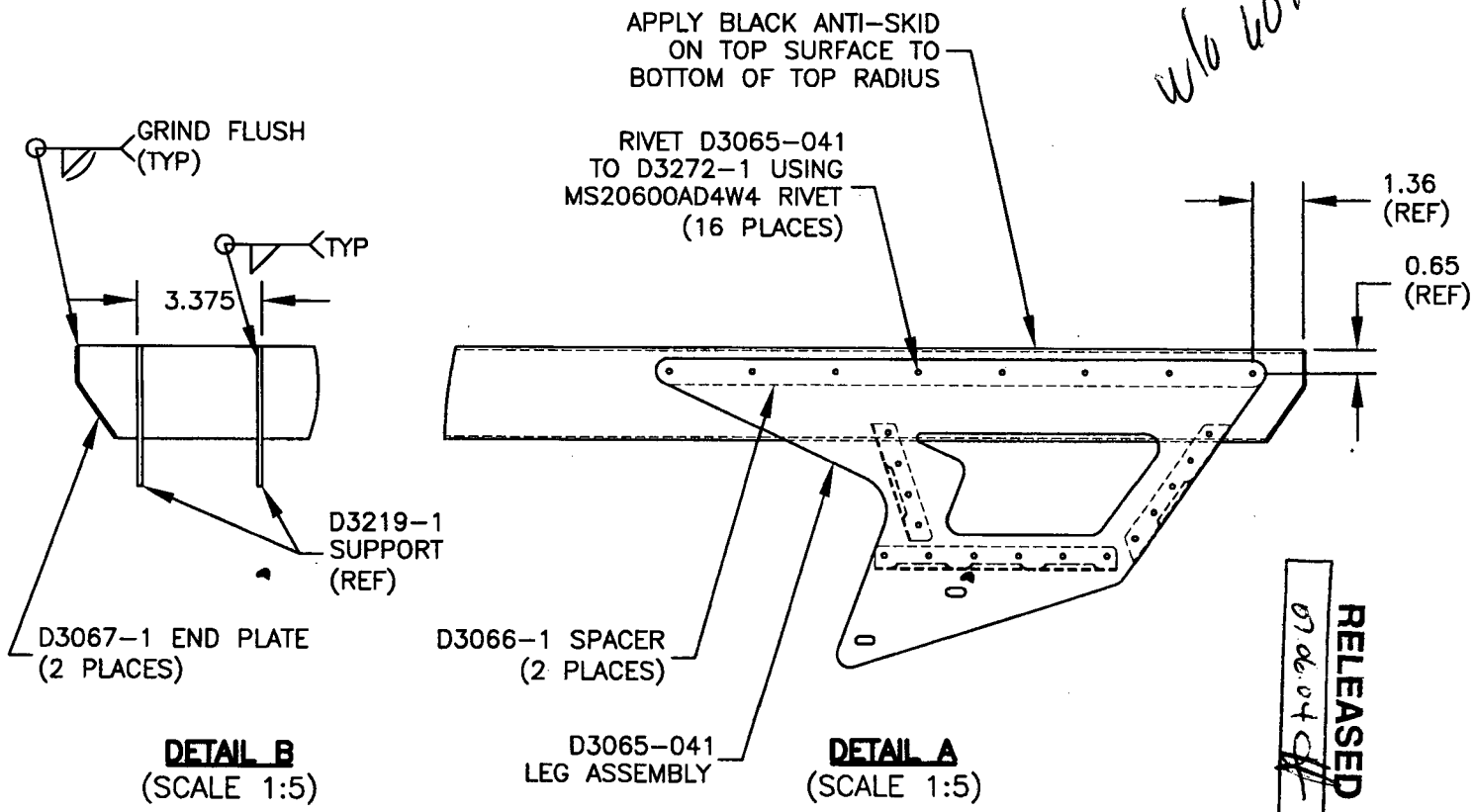
NOTE: Date & initial all entries



DESIGN	AP	DRAWN BY	JB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JB	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

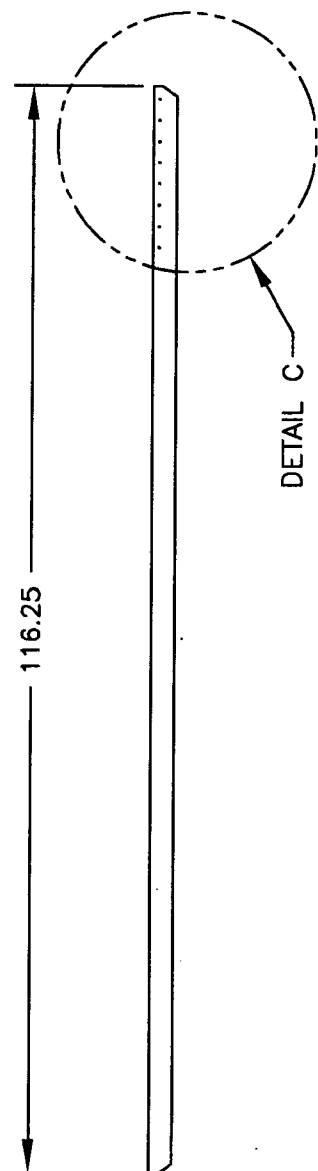
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



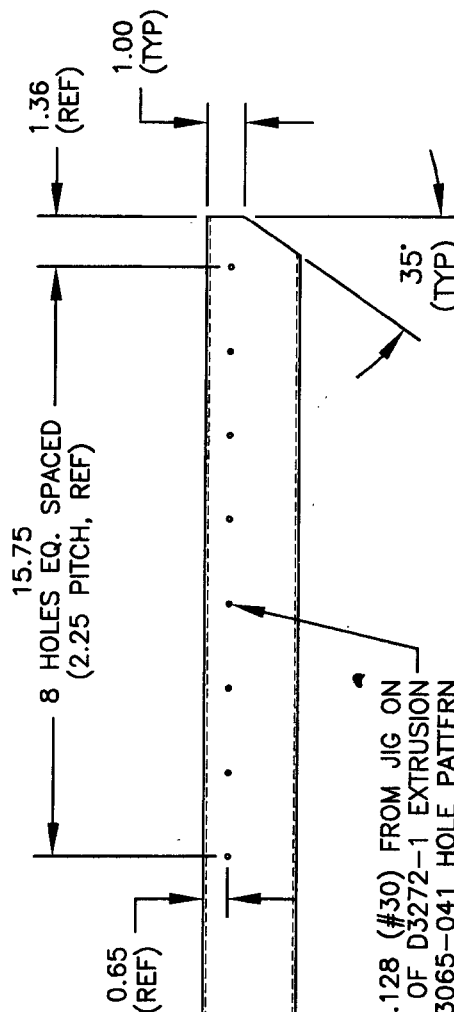
DESIGN <i>gp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

W/O 60767



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.